

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010114**Date Inspected:** 01-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 13-

This QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG segment 11AE longitudinal diaphragm to side panel weld, SEG006B-027. ZPMC welder was identified as 058551. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) of OBG segment 11CE FL2 floor beam to Bottom panel welds, SSD20 PP103-108~128. ZPMC welder was identified as 055564. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132.

Shielded metal Arc Welding (SMAW) of OBG segment 11BE FL3 side panel stiffener splice welds, SP595-001-083~085. ZPMC welder was identified as 067752. ZPMC QC is identified as Lv Li Qing. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2214-B-U2-FCM-1.

OBG Trial Assembly-

This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for

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detection of planar transverse indications.

UT performed on portion of OBW1A-005, 006 and 007 utilizing scanning pattern A, B, C and D (Fig 6.7)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 1st , 2009 for further information on inspections.

This Inspection is in response to ABF's Verification Witness no. 10312009-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
